

Date: Thursday, 6/15/2006 1:51:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT
 Job Number : 27593B
 Estimate Number : 10462
 P.O. Number : N/A Part Number : D32782
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D3278 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 24568B Material : N/A
 Due Date : 7/5/2006 Qty: 30 Um: Each
 Written By : *SEA GUYMAN Below*
 Checked & Approved By : *JA 06.06.15*
 Comment : Est:A 04.04.19 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.4572 f(s)/Unit Total: 13.7151 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick

(M6061T6B1.000x02.000)

Batch: ~~1118-00~~

M101000

J.F. 06/06/20 (30)

2.0 SHEAR SHEAR



Comment: ~~SHEAR~~ *Band SAW*

Cut blank: 2.00" x 1.00" x 2.550" long

J.F. 06/06/20 (30)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278

2- Deburr and Tumble

Identify as D3278-2

/J.F. 06/06/22 (30)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

/J.F. 06/06/22 (30)


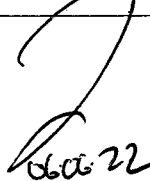

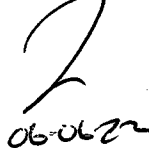
5.0 QC8 SECOND CHECK




Comment: SECOND CHECK

J.G. 06/06/22 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/22	3	The piece is to thin 2 parts scrap. parts didn't sit well in the vise		Scrap & destroy & replace	J.F. 06/06/22			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/04

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:51:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 27593B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H.M 06-06-27

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M 06-06-29

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Pu/4/29 30

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 419

H.M 06-06-30

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 26/07/07

Job Completion



W 26/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27393B
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒
First Article
☐
Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.098	✓			
0.359	+/-0.005	0.359	✓			
0.615	+/-0.010	0.614	✓			
0.250	+/-0.010	0.249	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	R0.125	✓			
0.119	+0.005/-0.004	0.116	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.980	✓			
R0.130	+/-0.010	R0.130	✓			
Ø0.257	+0.005/-0.000	Ø0.288	✓			
R0.375	+/-0.010	R0.375	✓			
0.875	+/-0.010	0.874	✓			
0.500	+/-0.010	0.500	✓			
R0.400	+/-0.010	R0.400	✓			
1.720	+/-0.010	1.721	✓			
R0.125	+/-0.010	R0.125	✓			
0.125	+/-0.010	0.123	✓			

Measured by:	<i>gml</i>	Audited by:	<i>Er</i>	Prototype Approval:	N/A
Date:	06/06/21	Date:	06/06/21	Date:	N/A

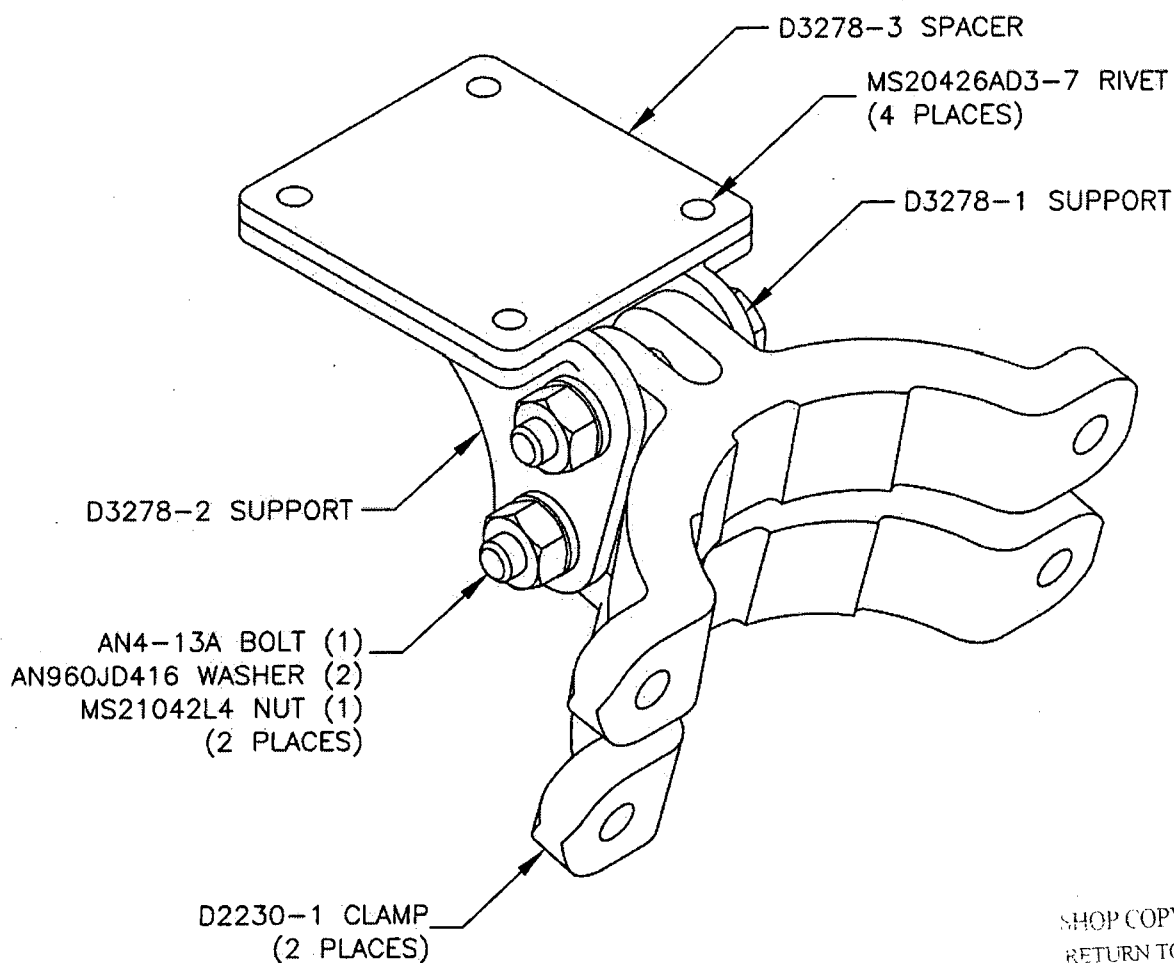
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	<i>gml</i>



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CHECKED		APPROVED		DRAWING NO. D3278 REV. B SHEET 1 OF 3
DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE		
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT		

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



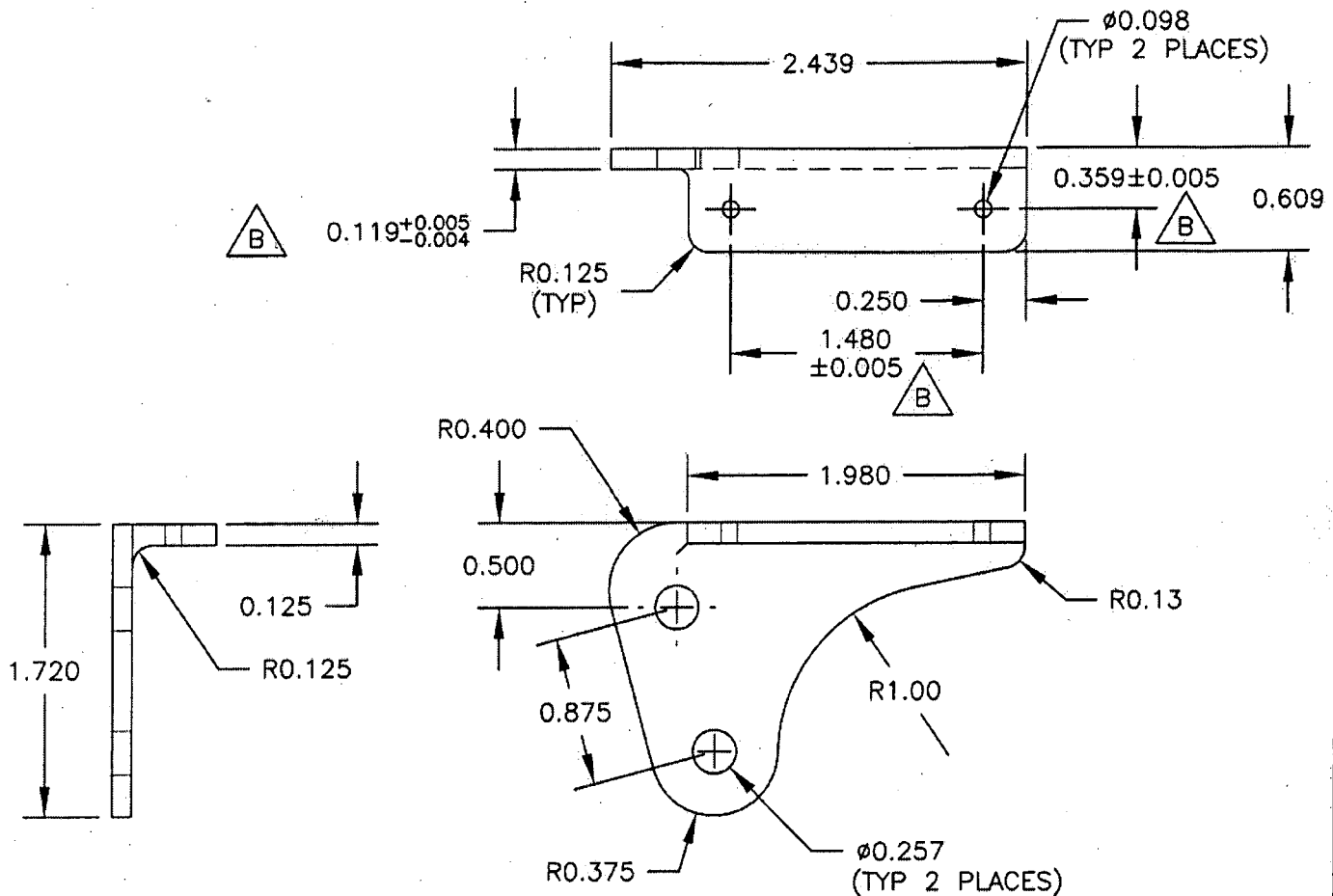
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPR1"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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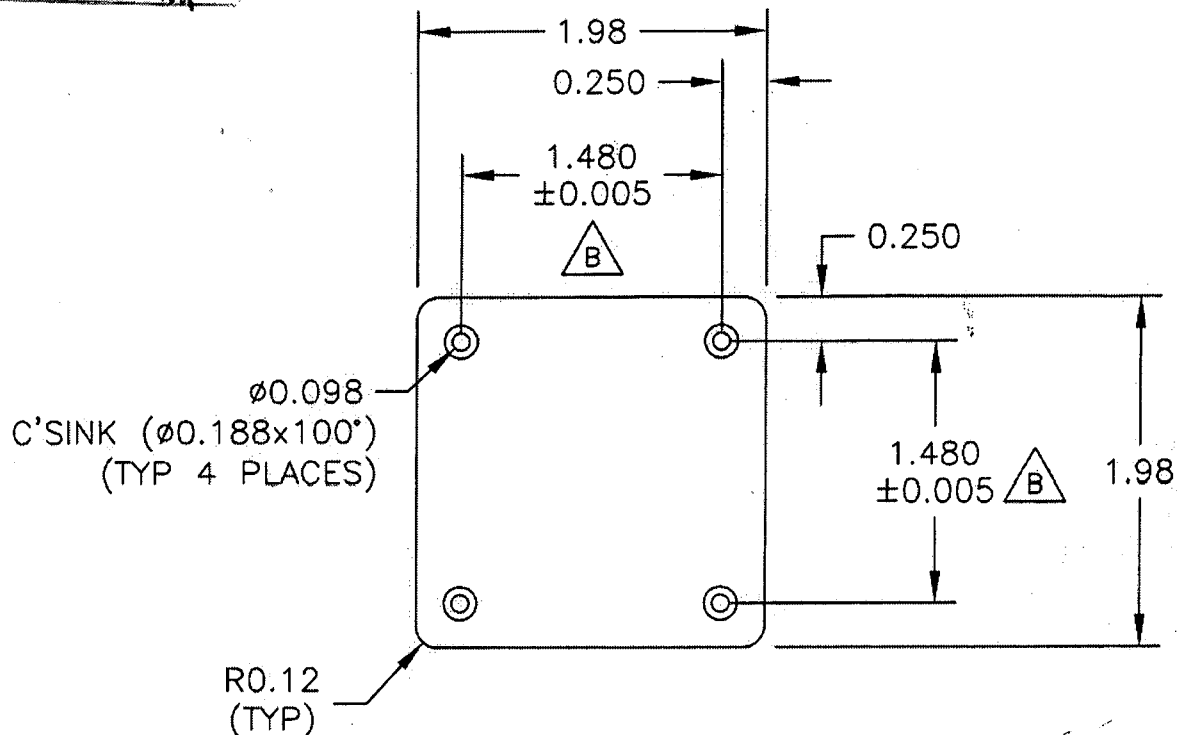
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CHECKED 	APPROVED 	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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